

Work Order ID 132728

Thursday, May 07, 2015 2:57:25 PM

132728

Page 1

Item ID: D3204-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Release Pedal Assembly
 Start Date: 5/7/2015 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 5/7/2015 Req'd Qty: 2.00 ***2*** Customer:
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Approvals: Process Plan: CL Date: MAR 08 2015 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3204	Rev A1								

100 Large Fab 0.00
100
 Large Fab Memo 0.03
 Large Fab
 1- Weld assembly as per Dwg D3204 using Jig D3204-041T1.
 2- Drill #40 diameter hole in the center of Ø0.760" c'bore on D3204-5 arm prior to weld.
 3- Use JB weld compound to plug the hole after assembly. 4- Grind JB weld flush after it is cured.

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00
110
 QC Memo 0.00
 Quality Control

DAS
9
9-09

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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120	QC5- Inspect part completeness to step on W/O	0.00							DAS 9 9-89
120						②	15-06-16		
QC	Memo	0.00							
Quality Control									
130	Chemical Conversion Coat per QSI005 4.1	0.00				2	φ		Jm 5-6-17
130									
HandFinish	Memo	0.00							
Hand Finishing									
140	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							DAS 34 9-89
140						2	φ	15-6-23.	
Powdercoat	Memo	0.00							
Powder Coating	***Cover holes for bushing*** START TIME: 1:55 OVEN TEMPERATURE: 200° FINISH TIME: 2:25.								

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC3- Inspect Part Finish	0.00							
150									
QC	Memo	0.00				2x			15/06/24
Quality Control									
160	Small Fab	0.00							
160									
Small Fab	Memo	0.00				2x			15/06/24
Small Fab	Install D3204-7 bushing as shown in Dwg D3204								
170	QC5- Inspect part completeness to step on W/O	0.00							
170									
QC	Memo	0.00				(2)			
Quality Control									

DAS 36 9-89
DAS 38 9-89
JUN 24 2015

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

Picklist Print

Thursday, May 07, 2015 2:57:25 PM

Page 1

Work Order ID: 132728

132728

Parent Item: D3204-041

D3204-041

Parent Item Name: Release Pedal Assembly

Start Date: 5/7/2015

Required Date: 5/7/2015

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP: C05.08.11Added Step 25 KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3204-1 *D3204-1* Tube		Manufactured	No			100	Each	16.0000	1	2			
** EL 15-6-10													
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						WA002	16						
						109095	16		2				
D3204-11 *D3204-11* Plate		Manufactured	No			100	Each	12.0000	1	2			
** EL 15-6-10													
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						WA002	12						
						103163	12		2				
D3204-13 *D3204-13* Gusset		Manufactured	No			100	Each	10.0000	2	4			
** EL 15-6-10													
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						WA002	10						
						108727	6		4				
						122494	4						
D3204-3 *D3204-3* Arm		Manufactured	No			100	Each	5.0000	1	2			
** EL 15-6-10													
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						WA002	5						
						116843	5		2				

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																								
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Picklist Print

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Page 2

Work Order ID: 132728

132728

Parent Item: D3204-041

D3204-041

Parent Item Name: Release Pedal Assembly

Start Date: 5/7/2015

Required Date: 5/7/2015

Start Qty: 2.00

Required Qty: 2.00

D3204-5 Manufactured No 100 Each 4.0000 1 2

D3204-5

Arm

EL 15-670

Location

Loc Qty

Loc Code

WA002

4

116831

4

2

D3204-9 Manufactured No 100 Each 6.0000 1 2

D3204-9

Pedal

EL 15-670

Location

Loc Qty

Loc Code

WA002

6

116752

6

2

D3204-7 Manufactured No 160 Each 10.0000 2 4

D3204-7

Bushing

15/06/24 DAS
36
9-89

Location

Loc Qty

Loc Code

GA

10

105460

10

4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

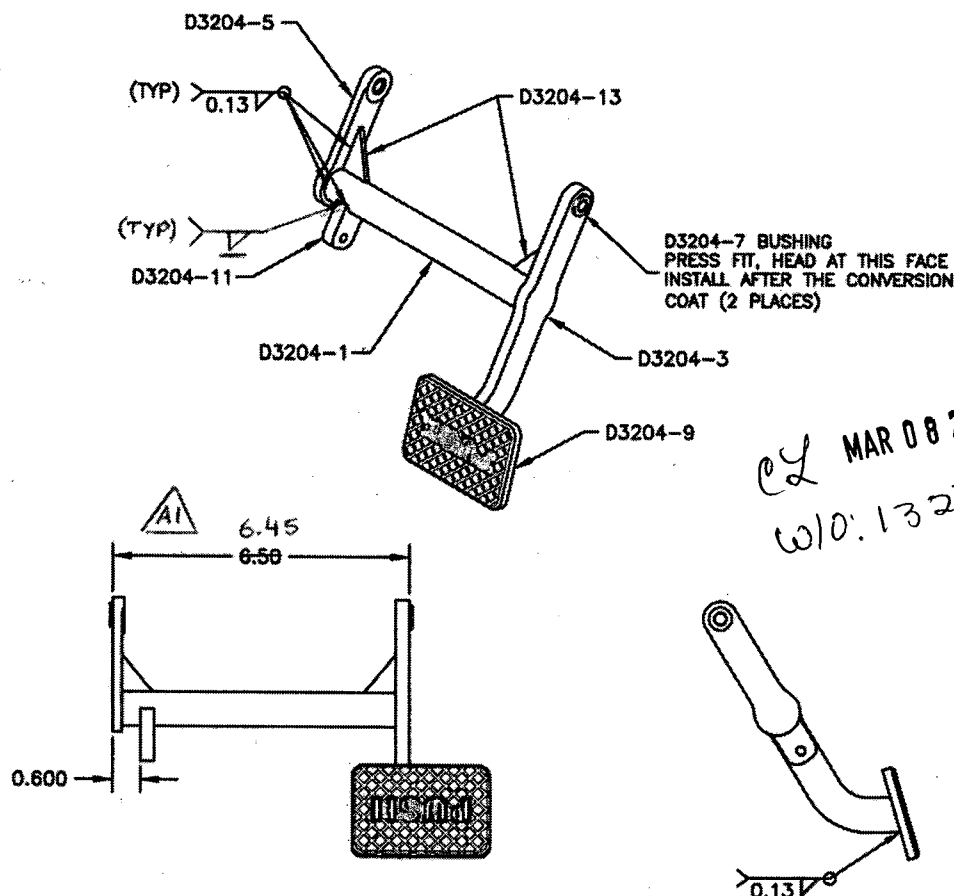
Work Order update only ☐

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OTHER :																																																																							



DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3204	REV. A SHEET 1 OF 3
DATE 04.01.27		TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS
A	04.01.27	NEW ISSUE	
A1	05.07.15	6.45 WAS 6.50	

RELEASED
04.04.30



D3204-041 RELEASE PEDAL ASSEMBLY

NOTES

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 OR -T62 (QQ-A-200/8) 0.750 OD x 0.125 WALL (M6061T6T0.75W.125)
- 3) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8) BAR (M6061T6B)
- 4) MATERIAL: AISI 303 SS (M303R)
- 5) MATERIAL: 6061 (QQ-A-250/11) SHEET 0.125 THICK (M6061T6S.125)
- 6) ENGRAVE "PUSH" USING 0.5" HIGH LETTERS TO DEPTH OF 0.010 TO 0.020
ENGRAVE DART P/N USING 0.125 LETTERS TO MAX DEPTH OF 0.010
- 7) WELD ASSEMBLY PER QSI 004
- 8) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 9) POWDER COAT ASSEMBLY GREY SANDTEX (REF. 4.3.5.6) PER QSI 005 4.3
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 11) ALL DIMENSIONS ARE INCHES

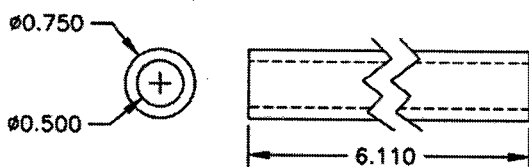
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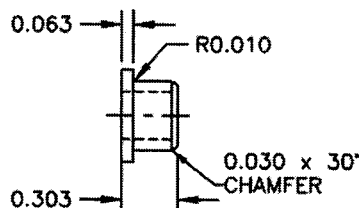


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CHECKED R	APPROVED R	DRAWING NO. D3204	REV. A SHEET 2 OF 3
DATE 04.01.27	TITLE RELEASE PEDAL ASSEMBLY		SCALE NTS

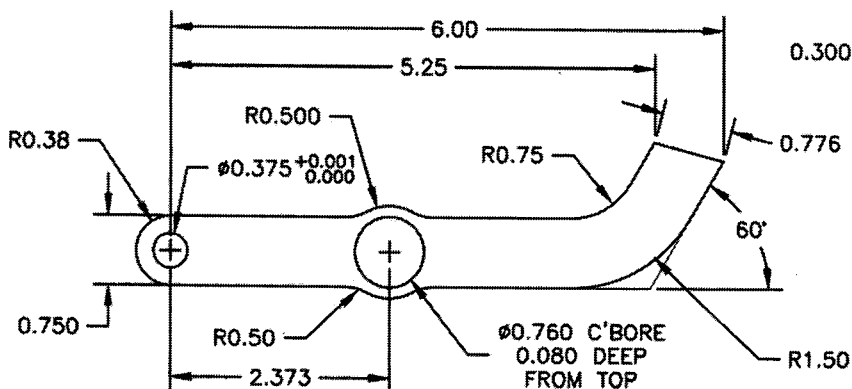
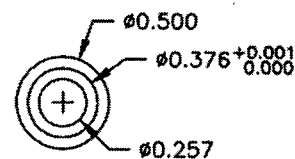
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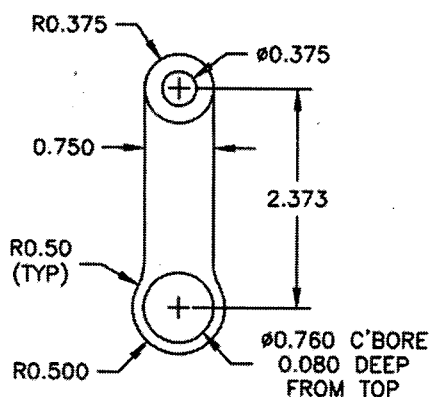
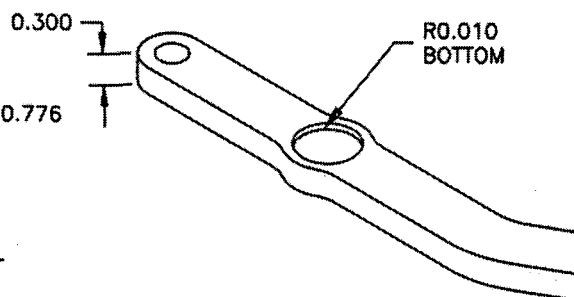
2 D3204-1 TUBE
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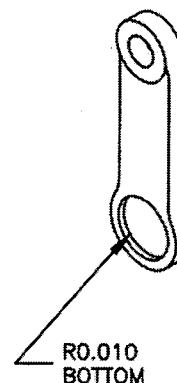
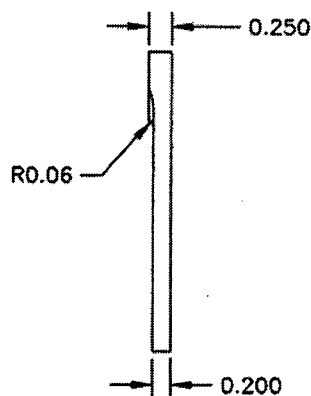
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3 D3204-3 ARM
SCALE 1:2



3 D3204-5 ARM
SCALE 1:2



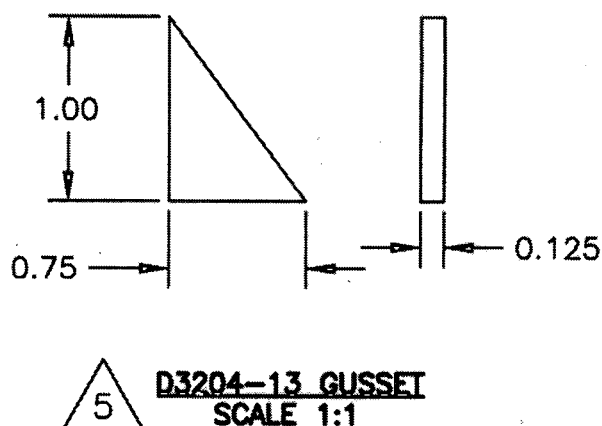
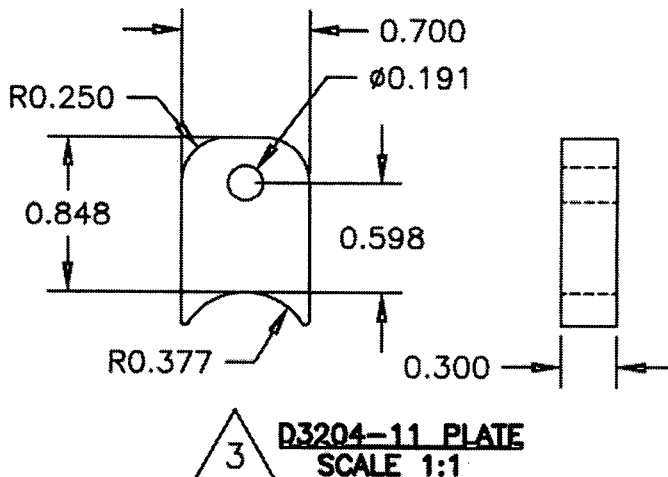
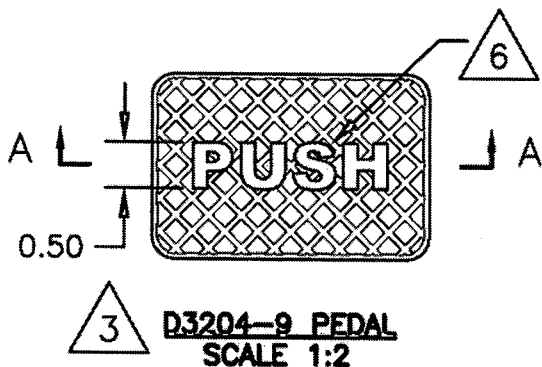
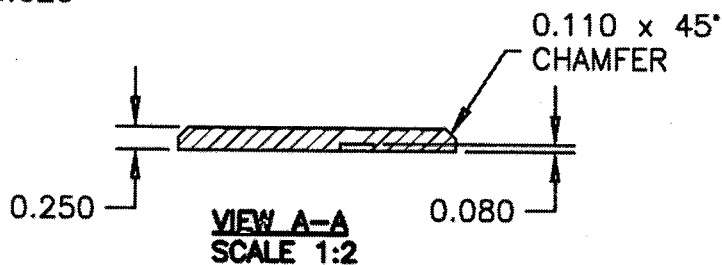
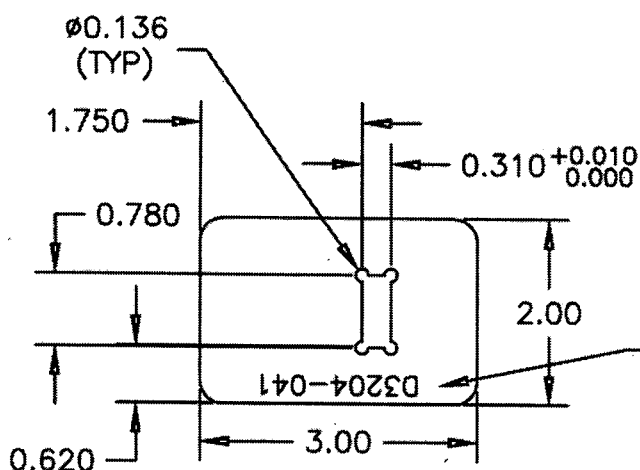
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DATE 04.01.27		TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS

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